



Dart Aerospace Ltd.
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D3162-041
Job Sheet 198441



Part No: D3162-041

Job Qty: 20 pcs

DAS
21
9-89

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/29/19

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 9/3/19

Description: Order 13294

Type: SOLD

Note: DWG REV C IPP A 02.05.14 New Issue NG IPP Rev:B 08-01-15 now on water jet DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	20 pcs		9/3/19	0.17	0.78	Waterjet - Flow	8/18/19	DAS 69 9-89
110	QC 2	20 pcs		9/3/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		
							QC 2 - 5		

120 QC 8	20 pcs	9/3/19	0.00 0.00	QC 2 - 71	DAS 89 9-89
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130 Small Fab - 2 - B4B	20 pcs	9/3/19	0.00 0.46	Small Fab - 1 - B4B	SMB 19/8/04
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
132 Small Fab - Brake NC - B4B	20 pcs	9/3/19	0.25 0.79	Small Fab - Brake - 1 - B4B	DAS 89 SEP 3 2019
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
135 QC 5	20 pcs	9/3/19	0.00 0.00	QC 5 - 10	DAS 81 9-89 SEP 04 2019
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
140 Handfinish - 1-1 Chemical-	20	9/3/19	0.00 0.26	Handfinish - 1 - 1 - B4B	

B4B	pcs				Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	SEP 04 2019
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150 Small Fab - 3 - B4B	20 pcs	9/3/19	0.00 0.46		Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	SEP 05 2019
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
160 QC 5	20 pcs	9/3/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	DAS
					QC 5 - 50	81
					QC 5 - 30	9-89
					QC 5 - 40	SEP 05 2019
					QC 5 - 61	
					QC 5 - 81	
170 Packaging 3-1 - Stock - B4B	20 pcs	9/3/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	

				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC ST 019
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
180 QC 21 - SA	23 pcs	9/3/19	0.00 0.00	QC 21 - SA - 21	PC ST 019
				QC 21 - SA - 70	DAG
				QC 21 - SA - 53	21
					SEP 05 2019

Part Op **100** - 1-Cut as per Dwg D3162 Dwg Rev: _____ Prog Rev: _____ 2-Deburr if necessary

Descriptions: **110** - QC2- Inspect parts off machine FAI/FAIB
120 - QC8- Inspect parts - second check
130 - (Small Fab) 1-Deburr break all unmarked sharp edges .005 to 0.010 2-C'sink holes as per Dwg D3162
132 - (Bend/Assemble as per dwg) Form as per dwg
135 - QC5- Inspect part completeness to step on W/O
140 - Chemical Conversion Coat per QSI005 4.1
150 - (Small Fab) Assemble as per drawing
160 - QC5- Inspect part completeness to step on W/O
170 - Identify as per dwg & Stock Location: _____
180 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	.1656 sf (.0072 ea)	100-Waterjet - Flow - 1	SOL 2200
MS20426AD3-3	Rivet	46 Ea (2 ea)	150-Small Fab - 3 - B4B	3174201
MS21059L3	Nut Plate	23 Ea (1 ea)	150-Small Fab - 3 - B4B	19x3163612-2x3156431 2x3156435

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.063	0	447	0
150-Small Fab - 3 - B4B	MS20426AD3-3	46	5,897	0
	MS21059L3	23	121	0

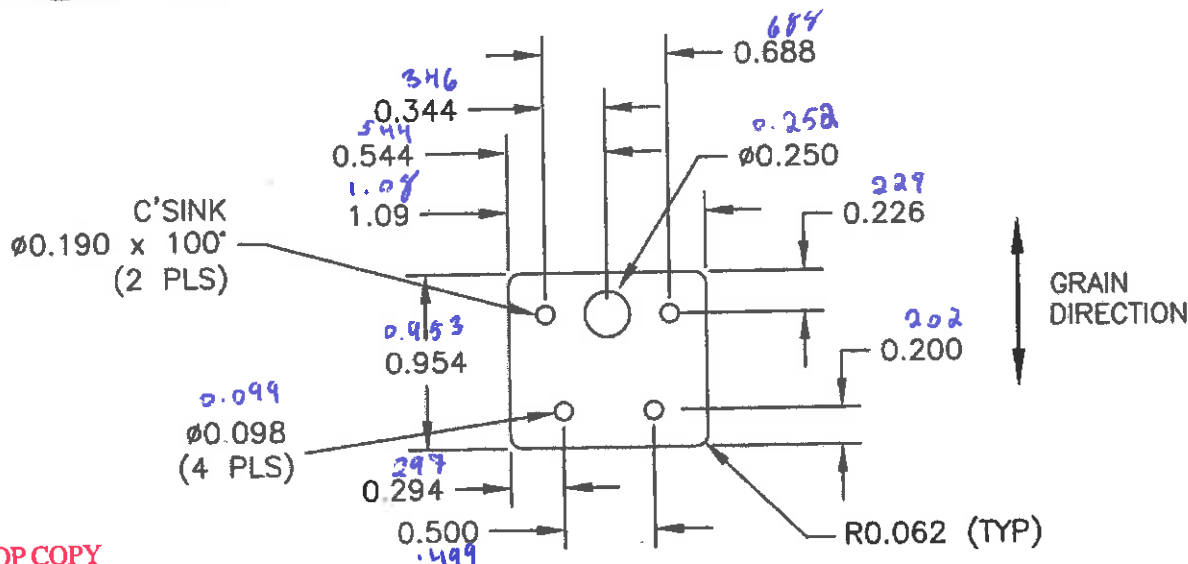
Part Specifications	
Specifications could not be found.	

Plex 9/4/19 3:00 PM dart.boucher.sylvie



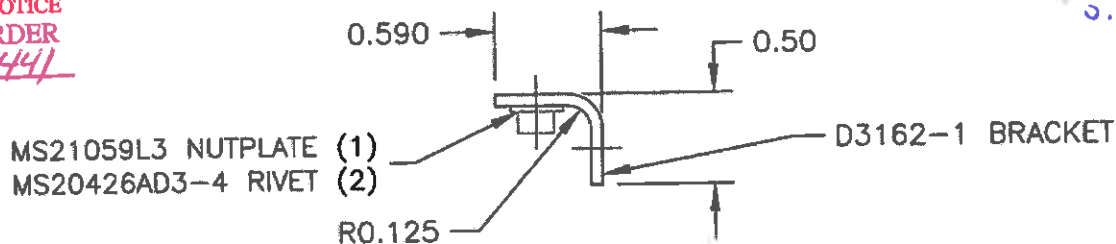
DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3162	REV. C SHEET 1 OF 2
DATE 05.10.05		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	02.04.30	NEW ISSUE	
B	04.10.18	ADD PART MARKING	
C	05.10.05	ADD D3162-3/-4	

RELEASED
05.12.01



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WITHOUT NOTICE
WORK ORDER
NO. 198441

D3162-1F FLAT PATTERN
(USED TO MAKE D3162-1 BRACKET)



D3162-041 BRACKET ASSEMBLY

NOTES:

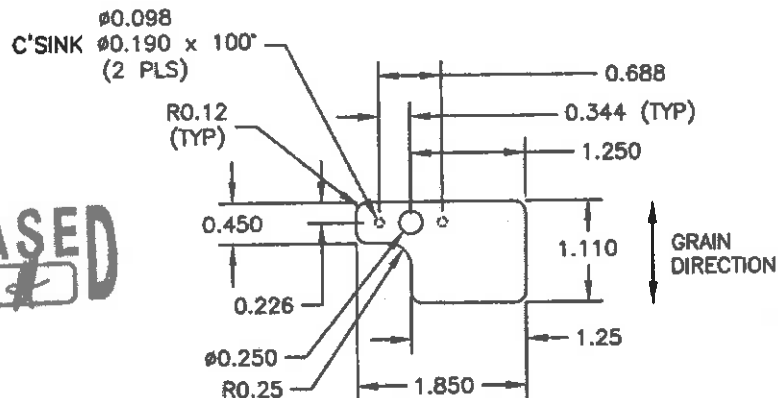
- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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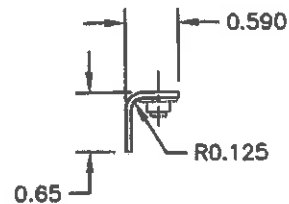
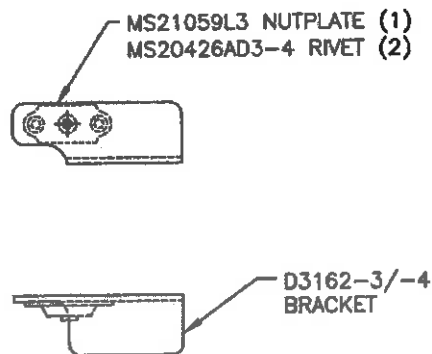
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DART

DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3162	REV. C SHEET 2 OF 2
DATE 05.10.05		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
05.12.01

D3162-3F FLAT PATTERN
(USED TO MAKE D3162-3/-4 BRACKETS)



D3162-043 BRACKET ASSEMBLY (SHOWN)
(D3162-044 BRACKET ASSEMBLY (OPPOSITE))

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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DART AEROSPACE LTD		Work Order:	198441
Description: Bracket Assembly		Part Number:	D3162-041
Inspection Dwg:	Rev: C	Page 1 of 1	

INSPECTION SHEET

[illegible]

Measured by:	69	Checked by:	40	QC Inspector:	
Date:	8/18/19	Date:	AUG 21 2019	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	